

# Work Order ID 64609



Page 1

Thursday, December 09, 2010 10:16:00 AM

Item ID: D206-642-151

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 12/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-12-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile &amp; type labels per PPP D206-642-151

CHG001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
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QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐ M116577/M 111385

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole &amp; 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 &amp; D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 &amp; doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

BE 11/05/12

BE 11/05/12

BE 11/05/12

BE 11/05/12

BE 11/05/13

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

*Handwritten signature and date: BEN 10/5/13*

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

*Handwritten signature: Sullivan*

*Handwritten mark: (X)*

W/O:		WORK ORDER CHANGES					
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Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open crossbolt holes to Ø0.3125"

2- Open Aft cap hole #6

\*\*\*\*no wearplate holes for this skidtube\*\*\*\*

3-Debur tube and blow out chips from inside the tube

N/A

140

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

1 of 11 1/15/17

150

0.00



QC3- Inspect Part Finish

QC

Memo

0.00

Quality Control

11-5-19

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:



Reference:

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Skidtubes	Skidtubes	0.00							
	<b>Memo</b>	0.00							
	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								
170  QC	QC6- Inspect dimensions to drawing	0.00							
Quality Control	<b>Memo</b>	0.00							

BE  
TW 11-05-19

DP 11-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

*[Handwritten signature]*

11-05-19

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: ☒ 11/05/09 Time: ☒ 4:25 PM

Finish Date: ☒ 11/06/09 Time: ☒ 11:00 AM

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Sikaflex-291 ☒ 117566 ☐

Sikaflex expire date: ☒ 12/01/15

*WH 11/05/09*

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*1 ✓ BE 11/06/09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

0.00



Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

BE 11/06/06

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch  
A/R ☐ Aluminum Rod ☒ M112860

BE 11/06/06

3-Grind welds flush as per Dwg D3804.

BB

11/06/06

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☒ NONE

BE 11/06/13

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 11/06/13

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
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Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210



HandFinish

HandFinishing

0.00

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

1 0 BR 11/06/13

220



QC

QC9- Inspect visual per QSI004- Fusion Welds

QC10

Memo

0.00

0.00

Quality Control

8 u/12/13

P10 →

230



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

8 u/12/13

(70)

W/O: 64609		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/04/13	# 22	Perm. change change to QC10 inspection	B	11.06.28	N/A	N/A	S 11/04/13	

Part No: D206-642-151 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 0 11/10/14

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:30  
320°F  
8:00

0.00

Powder Coating

M 116964

1X 0 M-11/06/16

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 BK 11-6-16

W/O:		WORK ORDER CHANGES					
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Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

1 - ~~BL~~ 11-6-16.

280

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive  
A/R ☐ ☐ Sikaflex-291 ☐ 117516 ☐ ☐  
Sikaflex expire date: ☐ 15-01

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4 ☐  
Batch: 117863.1 - ~~BL~~ 11-6-16.

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
300	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
310	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-151								
	Location: _____								
	PPP Rev: _____								

PPD 64615

11/6/2010

W/O:		WORK ORDER CHANGES					
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Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/23 JF  
MF  
11-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, December 09, 2010 10:16:04 AM

Page 1

Work Order ID: 64609

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube







Start Date: 12/9/2010





Start Qty: 1.00

Required Date: 1/14/2011

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV:N DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620  Skidtube, 206 Skidtube		Manufactured	No		68135		Each	9.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				9					
					62684			9					
D3286-1  Doubler		Manufactured	No				Each	23.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST050				23					
					52844			23					
D2647  Cap		Manufactured	No				Each	57.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP				57					
					55352			57					
CR3212-4-04  Cherry Rivet		Purchased	No				Each	425.0000	52	52			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST311				425					
				112314				25					
				113749				200					
				115698				200					
				116471									





  
 11/05/12  
 11/06/13  
 11/05/12  
 11/05/12  
 53 JW 11/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Thursday, December 09, 2010 10:16:04 AM

Work Order ID: 64609



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-1 Manufactured No

*R64781*

Each 0.0000 1 1



Web

D2649 Manufactured No

Each 53.0000 19 19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG	53	
58545	2	
60652	4	
61496	2	
62889	13	
63359	32	

D3286-3 Manufactured No

Each 7.0000 2 2



Spacer

Location

Loc Qty

Loc Code

LG	7	
46643	7	

CCR264SS3-3 Purchased No

Each 330.0000 2 2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311	330	
112314	4	
113539	44	
113973	282	

*OK 11/05/20*

*BE 11/06/13  
Q 68224 v19*

*BE 11/06/13  
Q 64564 v1*

*BE 11/06/13  
M117849 v2*

Thursday, December 09, 2010 10:16:04 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 3

Thursday, December 09, 2010 10:16:04 AM

Work Order ID: 64609

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

Each

1,873.000

2

2



Cherry Rivet



BE 11/06/13

LocationLoc QtyLoc Code

ST311

1873

110153

35

111359

5

112314

2

114436

448

114450

37

114859

1346

2

D2680-041

Manufactured

No

Each

20.0000

1

1



Nut Plate

BE 11/06/13  
Q 70088 x1LocationLoc QtyLoc Code

ST021

20

55366

20

D3805-041

Manufactured

No

Each

0.0000

1

1



Wearplate Assembly Fwd, Low Gear

64565



1

BL 11-6-16.

D3805-045

Manufactured

No

Each

0.0000

1

1



Wearplate Assembly Aft, Low Gear

64566



1

BL 11-6-16.

AN3-37A

Purchased

No

Each

654.0000

7

7



Bolt



7

7 BL 11-6-16.

LocationLoc QtyLoc Code

ST353

654

105425 ✓

154

111668

500

Thursday, December 09, 2010 10:16:04 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, December 09, 2010 10:16:05 AM

Work Order ID: 64609

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J ✓ Purchased

No

Each

8.0000

7

7



Washer

Location

Loc Qty

Loc Code

ST 117291

6

107715

6

ST335

2

105792

2

7 BR 11-6-16.

MS21042L3

Purchased

No

Each

1,213.000

7

7



Nut

Location

Loc Qty

Loc Code

ST300 116549

1213

114784

217

115835

996

7 BR 11-6-16.

D3873-1

Manufactured

No

Each

81.0000

14

14



Bushing

Location

Loc Qty

Loc Code

ST092 68247.

70

62197

40

63314

30

ST093

11

57615

11

14 BR 11-6-16.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, December 09, 2010 10:16:05 AM

Work Order ID: 64609

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD416 NAS1149D0463J Purchased No

Each 30.0000 1 1



Washer

Location	Loc Qty	Loc Code
----------	---------	----------

ST300 117460	24	
113288	24	
ST356	6	
115622	6	

1 BR 11-6-10

D2651-1 Manufactured No

Each 539.0000 6 6



Plug

57869

6 BR 11-6-10

Location	Loc Qty	Loc Code
----------	---------	----------

FP	217	
51530	152	
62638	65	
fpa	322	
53349	205	
57869	117	

D2651-3 Manufactured No

Each 432.0000 6 6



O-Ring

Location	Loc Qty	Loc Code
----------	---------	----------

FP 66956	432	
46114	12	
61962	420	

6 BR 11-6-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, December 09, 2010 10:16:05 AM

Work Order ID: 64609

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06 Purchased No

Each 95.0000 1 1



Screw



Location Loc Qty Loc Code

ST292 95

109061 5

115460 90

Each 76.0000 1 1

D2646 Manufactured No



Aft Cap



Location Loc Qty Loc Code

FP-4 17

57332 17

FP6 5

52663 3

63633 2

Return 2010 54

62678 54

Each 1,364.000 2 2

MS27039-1-08 Purchased No



Screw



Location Loc Qty Loc Code

ST291 1364

107378 1

108077 37

110835 455

115108 871

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 7

Thursday, December 09, 2010 10:16:05 AM

Work Order ID: 64609

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L

NAS1149D03321

✓ Purchased

No

M 117391

Each

38.0000

2

2



2

BL 11-6-16

Washer

Location

Loc Qty

Loc Code

ST182

38

104885

38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

#### NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 64-609-  
B/10-12-14

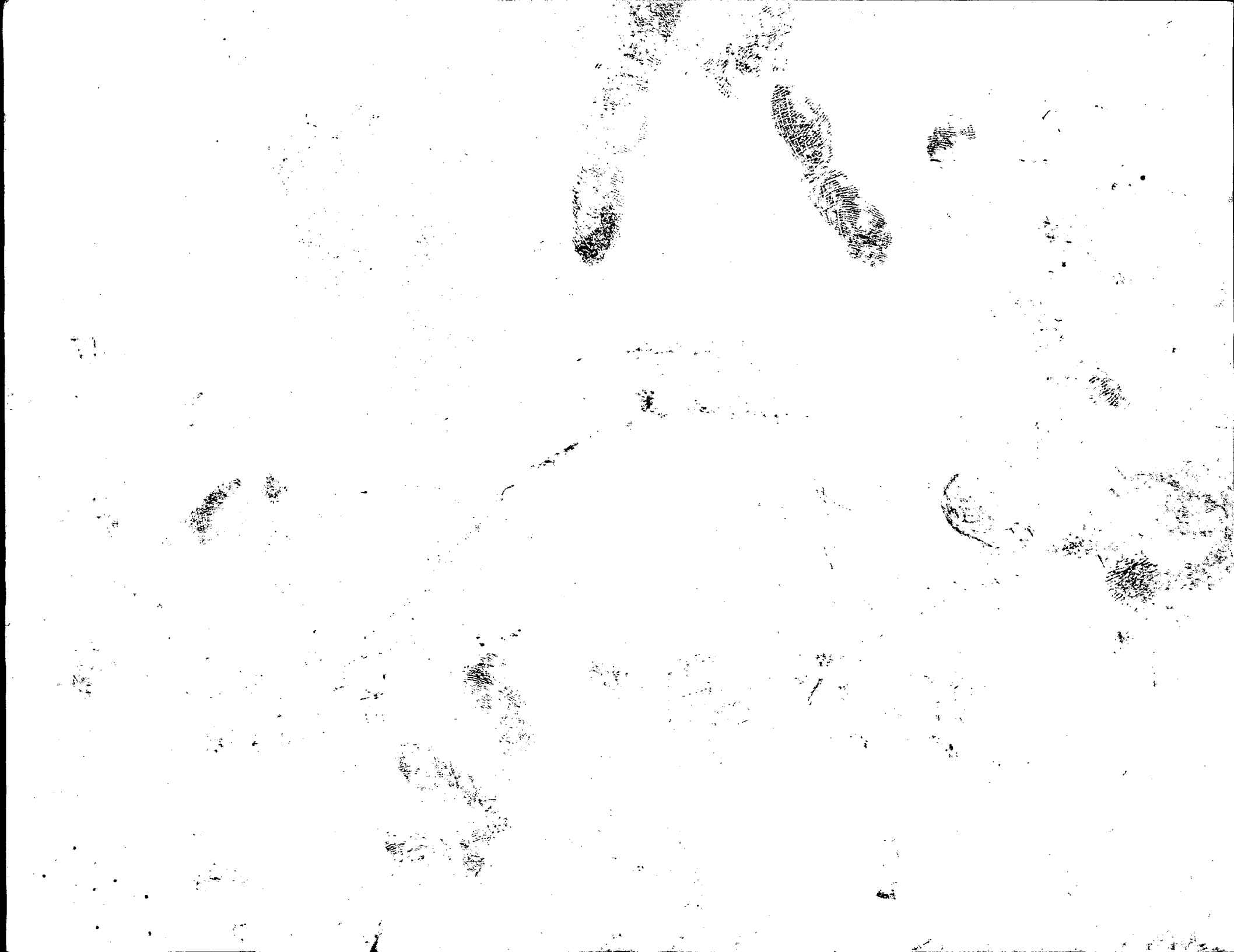
RELEASED  
09.03.03  
per ECR 09-538

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DRAWN	97		
CHECKED	97		
MFG. APPR.	97		
DE APPR.	97		
DATE	08.07.07		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. D3804  
TITLE SKIDTUBE ASSEMBLY, 206A/B  
REV. A  
SHEET 1 OF 5  
SCALE NTS

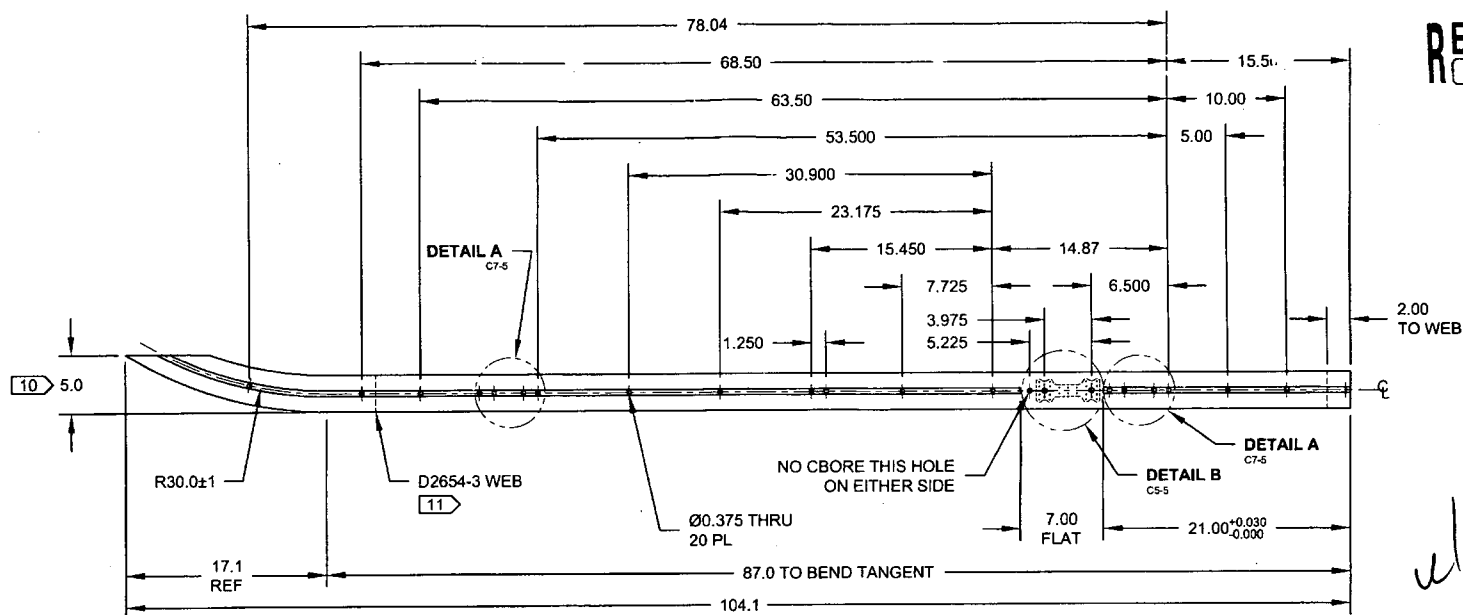
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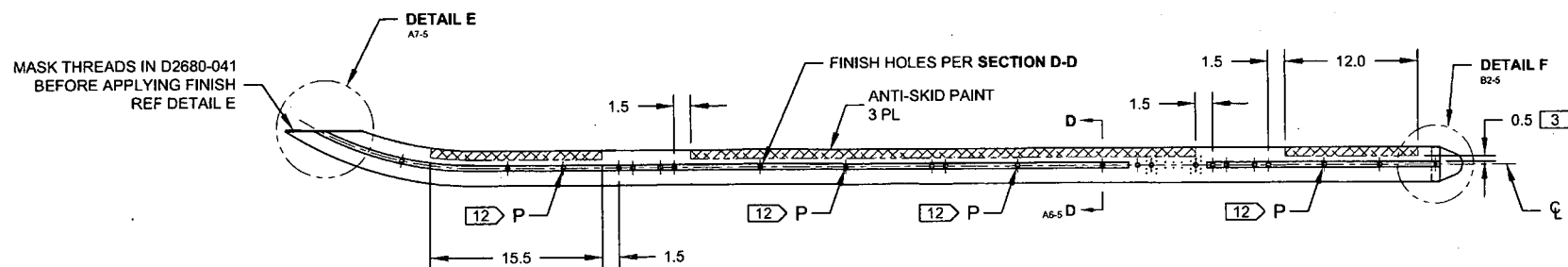




RELEASED  
09-23-07



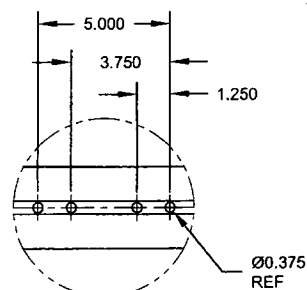
**D3804-043 BENDING/DRILLING DETAIL**



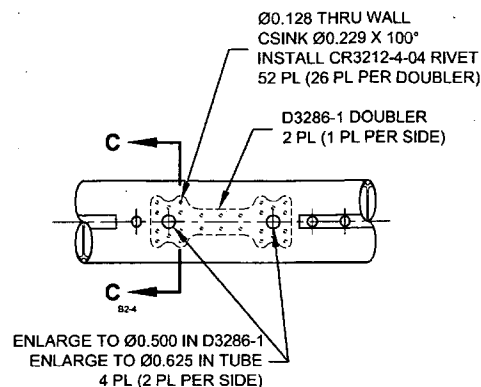
**D3804-043 ASSEMBLY/FINISHING DETAIL**

DESIGN	97	<b>DART AEROSPACE USA, INC</b>	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

**RELEASED**  
*UP 09.03.03*



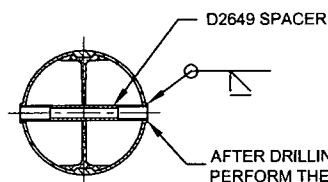
**DETAIL A** D6-2  
 C2-2  
 D6-3  
 C2-3  
 SCALE NONE



**DETAIL B** C3-2  
 C3-3  
 SCALE NONE

- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE AND GRIND FLUSH

**SECTION C-C** C6-4  
 PARTIAL SECTION  
 SCALE NONE



**SECTION D-D** A4-2  
 A4-3  
 FOR Ø0.375 HOLES ONLY  
 SCALE NONE

DESIGN	<i>91</i>	<b>DART AEROSPACE USA, INC</b>	
DRAWN	<i>J</i>	PORT HADLOCK, WA	
CHECKED	<i>91</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>91</i>	D3804	SHEET 4 OF 5
APPROVED	<i>91</i>	TITLE	SCALE
DE APPR.	<i>91</i>	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

RELEASED  
07.07.07

CCR264SS3-3  
RIVET  
2 PL

CR3212-4-03 RIVET  
2 PL

**VIEW G-G**  
SCALE NONE  
A7-5

D2647 CAP, TO INSTALL:  
1. CUT TUBE LEVEL  
2. REMOVE RIDGE ON FWD SIDE  
3. LOCATE D2647 (TRIM AS REQD)  
4. WELD D2647 IN PLACE  
5. GRIND FLUSH  
6. RIVET D2680-041 NUT PLATE  
IN PLACE

MS27039-4-06 SCREW  
AN960JD416 WASHER

D2680-041  
NUTPLATE

1.0 REMOVE RIDGE ON  
INSIDE OF SKIDTUBE  
LEAVE 0.070 MIN.

**DETAIL E**  
SCALE NONE  
B7-2  
B7-3

0.400

END OF WEB

BORE OUT END  
OF SKIDTUBE  
TO 0.75 DEPTH  
AND 0.070 WALL

SEAL WITH  
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204  
REF

MS27039-1-08 SCREW  
AN960JD10L WASHER  
2 PL

**DETAIL F**  
SCALE NONE  
B2-2  
B2-3

*abc4609*

DESIGN	<i>JP</i>	<b>DART AEROSPACE USA, INC</b>	
DRAWN	<i>JP</i>	PORT HADLOCK, WA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JP</i>	D3804	SHEET 5 OF 5
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



NO. 252

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 66358  
Part number: D206 642 541  
Description: 206  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Burns Date of Test Coupon 11-05-09  
Welder Barclay Elliott Date of Test Coupon 11-05-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld